

Work Order ID 134542

Wednesday, July 08, 2015 3:19:06 PM

134542

Page 1

Item ID: D4842-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lower Cutter Assembly
 Start Date: 6/28/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/10/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: JUL 09 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4842	REV B

110	Pick Kit	0.00
-----	----------	------

110

Packaging	Memo	0.00
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Packaging

120		0.00
-----	--	------

120

Small Fab	Memo	0.00
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Small Fab Assemble as per dwg and apply loctite 598 on all faying surfaces.

A/R LOCTITE 598: M131311

130	QC5- Inspect part completeness to step on W/O	0.00
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130

QC	Memo	0.00
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Quality Control

3A0J
DAS
36
9-89

1X 15/07/14

3A0J
DAS
36
9-89

1X 15/07/15

① 15-07-17
DAS
36
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

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140	Identify as per dwg & Stock Location <u>CC/COSS</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

DAS JUL 19 2015
6
9-89

MLS JUL 20 2015

MLS JUL 20 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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D4842-041

Required Date: 7/10/15

Required Qty: 1.00

Comments: IPP REV:A 13.04.30 NEW ISSUE DD VERF:JLM
REV:B 13.11.01 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4839-1		Manufactured	No				Each	10.0000		2			
D4839-1									**			DAS 30 9-89	JUL 14 2015
Blade													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MF		10		B134649					
					133453	10							
D4842-1		Manufactured	No				Each	8.0000		1			
D4842-1									**			DAS 30 9-89	JUL 14 2015
Lower Cutter Deflector													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MF		8							
					100670	1							
					107947	3							
					109250	4							
D4842-3		Manufactured	No				Each	5.0000		1			
D4842-3									**			DAS 30 9-89	JUL 14 2015
Lower Cutter Body, LH													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MF		5							
					107957	3							
					109251	2							

DQA: _____ Date: _____



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Picklist Print

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Parent Item: D4842-041

D4842-041

Parent Item Name: Lower Cutter Assembly

Start Date: 6/28/15

Required Date: 7/10/15

Start Qty: 1.00

Required Qty: 1.00

D4842-4

Manufactured No

Each

10.0000

1

DAS
30
9-89

JUL 14 2015

D4842-4

Lower Cutter Body, RH

Location

Loc Qty

Loc Code

MF

10

108070

1

109252

9

MS21042L08

Purchased

No

Each

926.0000

6

DAS
30
9-89

JUL 14 2015

MS21042L 08

Nut

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST260a

501

m131697

501

ST304

324

123900

16

m128401

102

m128429

3

m131317

203

MS27039-08-19

Purchased

No

Each

524.0000

6

DAS
30
9-89

JUL 14 2015

MS27039-08-19

Screw

Location

Loc Qty

Loc Code

ST273A

438

m131317

438

ST281

86

m127904

3

m131264

83

Wednesday, July 08, 2015 3:19:06 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Picklist Print

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Page 3

Work Order ID: 134542

134542

Parent Item: D4842-041

D4842-041

Parent Item Name: Lower Cutter Assembly

Start Date: 6/28/15

Required Date: 7/10/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN832P

Purchased

No

Each

3,231.000

12

DAS

JUL 14 2015

NAS1149FN832P

Washer

30

~~9.89~~

Location

Loc Qty

Loc Code

ST260a

1732

125268

1732

st268

1499

125268

578

M130388

921

12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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